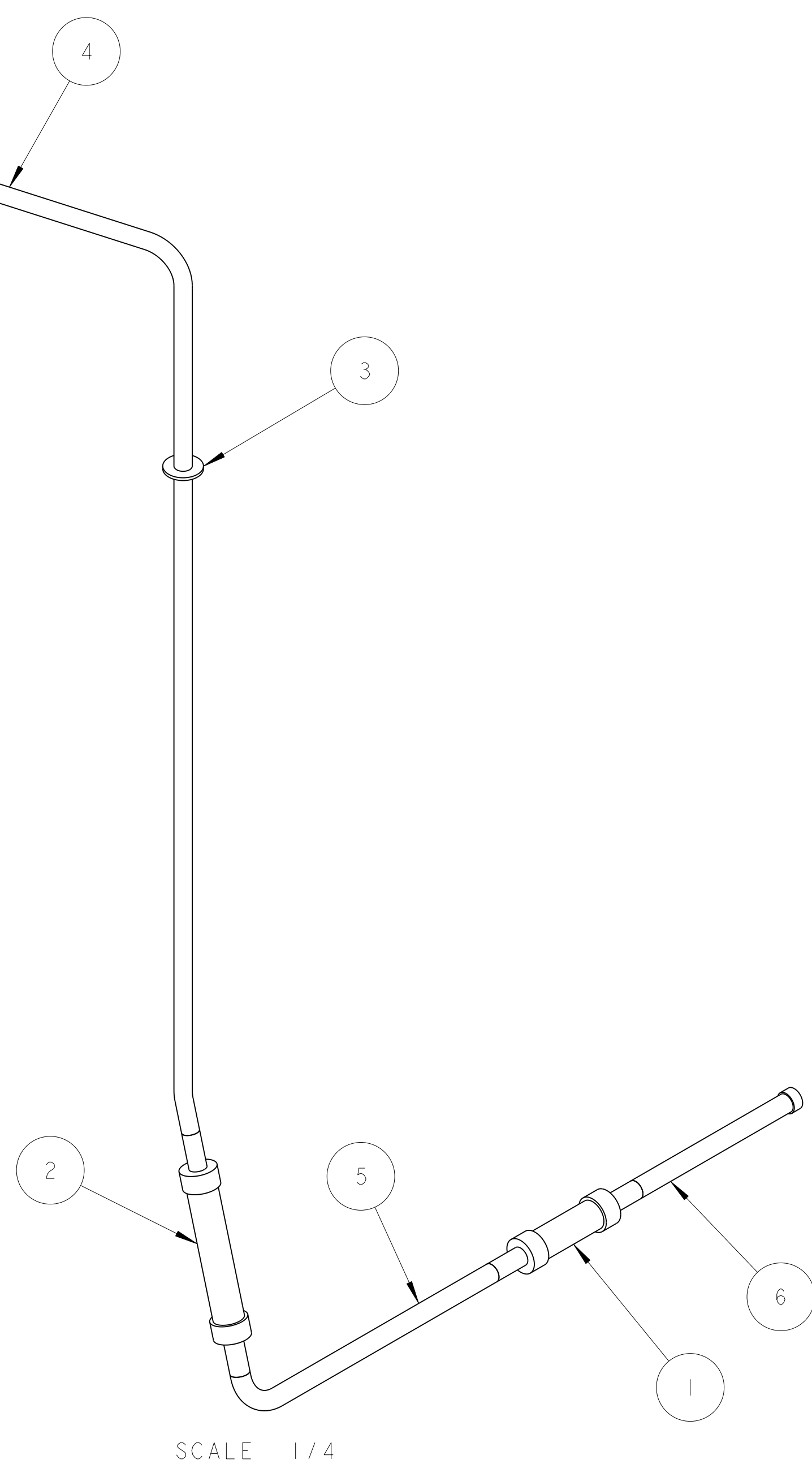


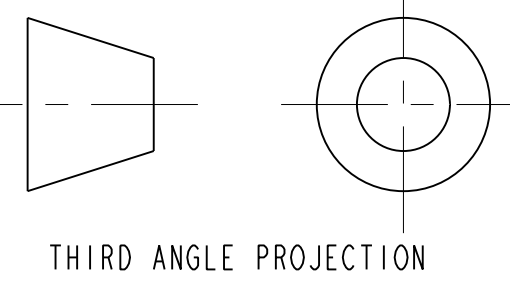
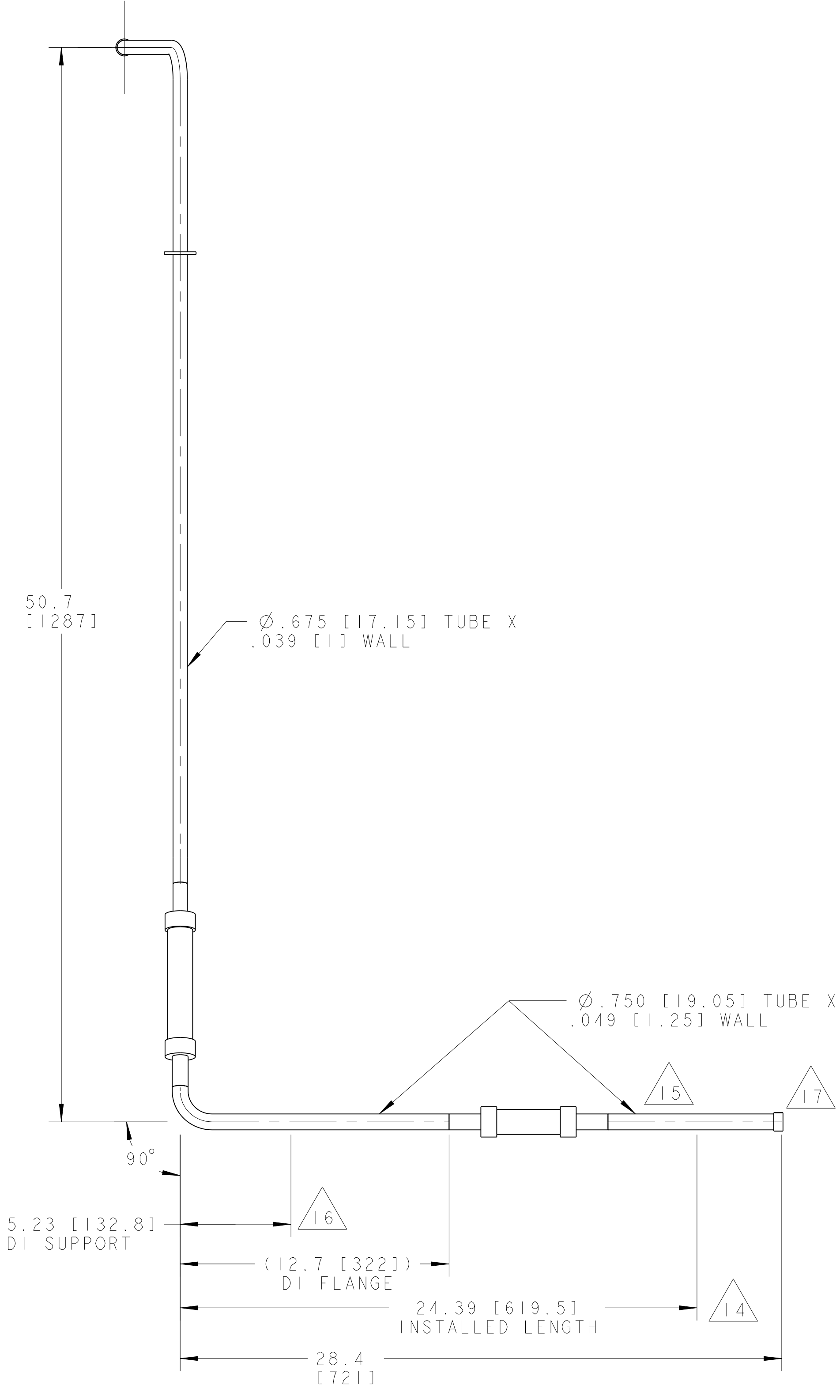
NOTES: (UNLESS OTHERWISE SPECIFIED)

1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
9. FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
10. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBECT TO LBNL APPROVAL.

11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
13. PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989.
14. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF 0.063".
15. PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
16. PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 1.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
17. CAP BOTH ENDS OF PIPE TO FACILITATE ACCEPTANCE TESTS.



SCALE 1/4



THIRD ANGLE PROJECTION

REV	DWG	CHK	DATE	ZONE	CHANGES
B	ARH	SPV	01/08/02		REVISED DRAWING NOTES 13, 16 & 17, MINOR DRAWING DIMENSIONAL CHANGES
A	ARH	SPV	11-26-02		INITIAL RELEASE

UNLESS OTHERWISE SPECIFIED
TOLERANCES
X.X ± 0.1 FRACTION ± 1/16
X.XX ± 0.03 ANGLES ± 1.00°
X.XXX ± 0.010 FINISH: 125/50µm
DO NOT SCALE PRINT
THREADS ARE CLASS 2
CHAMFER ENDS OF ALL SCREW THREADS 30°
CUT ROUNDS, 1.5 THREAD RELIEF ON MACHINED THREADS
BREAK EDGES, 0.15 MAX. ON MACHINED WORK
REMOVE BURRS, WELD SPATTER & LOOSE SCALE
IN ACCORDANCE WITH ASME B16.5 (B.1)

ITEM	PART NO.	REQD	TEST	NO.	DATE	RECD	DESCRIPTION	MATERIAL
6	-	1	TUBE, PER ASTM A269				SS 304L	
5	-	1	TUBE, PER ASTM A269				SS 304L	
4	-	1	TUBE, PER ASTM A269				SS 304L	
3	-	1	COLLAR				SS 304L	
2	-	1	BRAIDED FLEX HOSE, 3/4" ID X 5.4' LL				SS-300 SERIES	
1	-	1	BRAIDED FLEX HOSE, 3/4" ID X 3" LL				SS-300 SERIES	

SHOP ORDERS	DATE	NO.	DATE	NO.	DATE	NO.	DATE	NO.
ARH	01/08/02	1	01/08/02	1	01/08/02	1	01/08/02	1

ERNEST ORLANDO LAWRENCE	UNIVERSITY OF CALIFORNIA - BERKELEY	SCALE: 1/4	DO NOT SCALE
LHC IR FEEDBOX CRYOGENICS PIPE, E2		ASSEMBLY	REV. 1
DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE
ZSLCE2	LH2003	2512436	B